

Work Order ID 53373

November 3, 2009 7:48:08 AM



Page 1

Item ID: D4013-9

Accept



Setup Start



Revision ID: PRELIM 09.11.03

Stop



Item Name: Stud

Start Date: 03/11/2009 Start Qty: 10.00



Customer Item ID:
Customer:

PRELIMINARY ISSUE



Required Date: 03/11/2009 Req'd Qty: 10.00

Reference: *Just 09.11.03*

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4013	B-PRELIM

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

turn as per Dwg and Folio FA860

Folio Rev: *N/A*

Dwg Rev: *19/11/03*

Deburr

0.00

SA 09/11/03

10 *✓*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

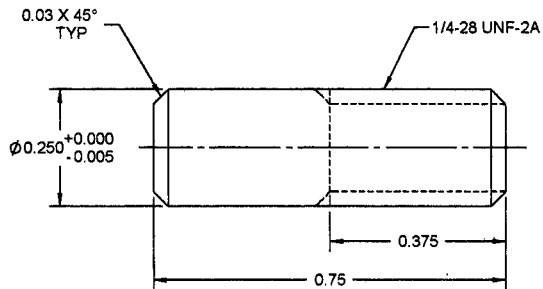
Quality Control

Memo

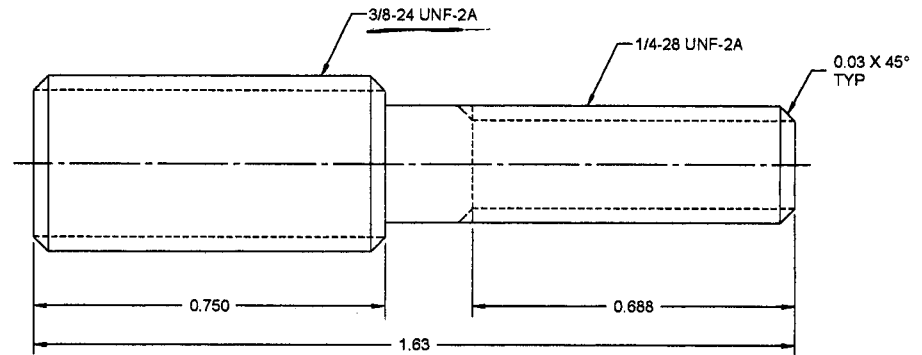
0.00

SA 09/11/03

10 *✓*

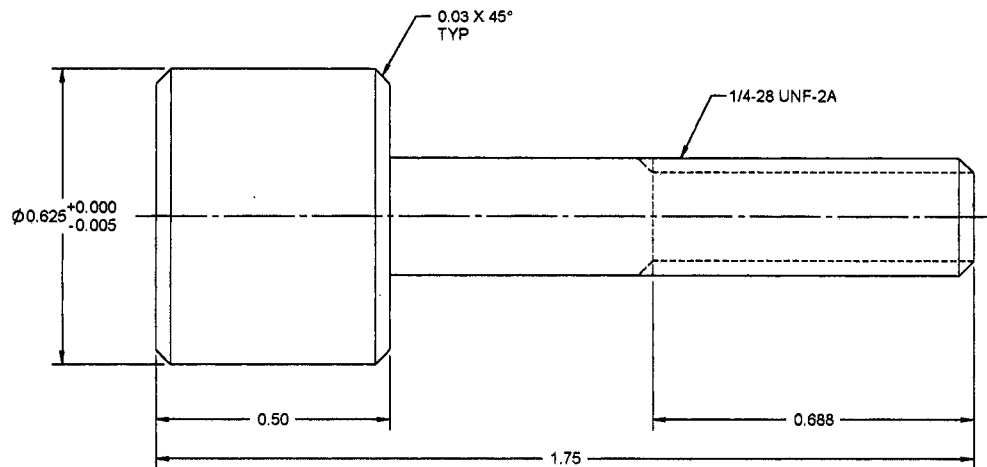


D4013-3 STUD



D4013-9 STUD

780



D4013-11 STUD

PRELIMINARY ISSUE
2011/03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4013	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	09.11.02	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Magna
5775 Kieran St, Saint
Phone: (514) 339-1211 Watts:

LD TO:
RT AEROSPACE LTD
70 ABERDEEN STREET

SHIP TO:
DART AEROSPACE
1270 ABERDEEN S

WESBURY
A 1K7
Contact: CHANTAL

HAWKESBURY
K6A 1K7
Ship Terms: PI

Currency		Sales Person	
CANADIAN DOLLARS		ERYCK BLAIS	
ales Order	Terms		
120337	NET 30 DAYS		NIR:R-55

Ordered	Back Ordered	Unit	Description
3		PC	ALUMINUM ANGLES AAN 6063 T5 3/4" x 3/4" x C OF C IS O.K
1		PC	ALUMINUM SQUARE BAR ASQ 6061 T6 2" x R/L
5		PC	STAINLESS ROUNDS SRB 304 1/2" x R/L

04/10/27

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Production/Admin: 9/1/27
Date Received/Costing:
Initial

Location

Initials of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M663754070W663		60	63	0	3	
M3478-0800		60	65	0	250	

Discrepancies

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐
QC6 Inspection: Yes ☒ No ☐
Work Order:

Date: 9/1/27
Supplier: Magna

Batch No: M113006
Part P/O: 10637

Receiving Report



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I018501

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SPECIAL INSTRUCTIONS

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO10631		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W020337	NET 30 DAYS		NIR:R-557065-1		10/23/09	10/26/09	10/26/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3		PC	ALUMINUM ANGLES AAN 6063 T5 3/4" x 3/4" x 1/16" x R/L 21' 6 LB / 3 PC C OF C IS O.K	L020061	NA	3
1		PC	ALUMINUM SQUARE BAR ASQ 6061 T6 2" x R/L 20' 94 LB / 1 PC	L024300	097U621	1
5		PC	STAINLESS ROUNDS SRB 304 1/2" x R/L 12'5" 42 LB / 5 PC	L020287	16162	5
Bundles: 1				Approx	Weight:	142 LB

10/4/09

Received by: _____ Date: _____ Signature: _____

10 IMPERIAL CHAMBERS, FIRST FLOOR,
WILSON ROAD BALLARD ESTATE MUMBAI
400 038 INDIA

CUSTOMER :

MAGNA STAINLESS INC (DIV OF CANADIAN
SPECIALTY METALS INC.)
525 MELOCHE AVE. DORVAL
QUEBEC CANADA H9P 2W2

INSPECTION CERTIFICATE

ORDER NO.
075646-AD1

PACKING LIST NO. INSPECTION NO
IMP/100885 IMP/100885/5

DATE
22/09/2008

BUNDLE NO.

2715614,2715623,2715684,2715685,2715686,2715719,2715728,2715750

GRADE
T-304

DESCRIPTION :

STAINLESS STEEL BRIGHT BARS L/C NO.: I700298 DT.: 26/09/2008

COLD DRAWN POLISHED

SIZE (INC)	SHAPE	TOLERANCE	LENGTH (FT)	PIECES	WEIGHT (LBS)
1/2	ROUND	ASTM A484	12' R/L	1083	8870

CHEMICAL ANALYSIS

HEAT NO. 16162

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N	Co
0.031	1.44	0.41	0.020	0.033	8.06	18.20	0.27	0.50	0.052	0.12

TEST RESULT

.2% YIELD STRENGTH KSI	TENSILE STRENGTH KSI	ELONGATION %	REDUCTION OF AREA %	HARDNESS BHN	GRAIN SIZE
93	109	42	72	221	7

Specification :

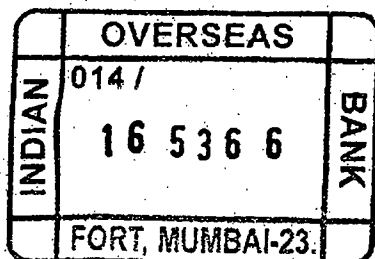
MATERIAL CONFIRMS TO ASTM A276-06 COND "A" TYPE 304, ASTM A 262-02A PRACTICE E, ASTM E 112-88(GRAIN SIZE). CERTIFICATION AS PER EN 10204-3.1.

OK 69.10.28

Remarks :

MATERIAL IS FREE MERCURY CONTAMINATION, FREE FROM WELD OR WELD REPAIRS. MINIMUM SOLUTION ANNEALING TEMPERATURE IS 1050 DEGREE
CENTIGRADE. SOAKING TIME: 1 HR / INCH. WATER QUIN CHED. MICRO: FREE FROM CONTINUOUS CARBIDE NETWORK ON GRAIN BOUNDARIES, MACRO: GOOD.
COUNTRY OF ORIGIN: INDIA

I hereby certified that the material described above has been tested and complies with the terms of order/contract.



S. Suvarna
WORKS INSPECTOR
S. SUVARNA

2017310



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10631

Purchase Order Date 10/23/09

PO Print Date 10/23/09

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FAXED
607/10/23

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

800 363 6646

Requisition Nbr

Vendor Fax

514 339 1105

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6063T5A0.750W.063	Angle6063T5 .750 X.750 X.063w	10/27/09	60.00	Yours ppd	\$0.5000	\$30.00
POSITIVE RECALL EFFECTIVE 09.10.27 AUTH <u>W</u> RELEASED <u>W</u> DATE 09.10.28 Special Inst: CFC OFFER ONLY							
2	M304R.500	304 SS roundbar .500	10/27/09	60.00	Yours ppd	\$2.0833	\$125.00
Special Inst: MATERIAL: AISI 304/316 STAINLESS STEEL ROD NOTE: AISI 303 NOT ACCEPTABLE							
3	M6061T6B2.000X02.000	6061-T6 Bar 2.00 x 2.00	10/27/09	20.00	Yours ppd	\$11.0000	\$220.00
Special Inst: MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR PER 4117/4128/4115/4116 OR QQ-A- 200/8 OR AMS 4160 OR ASTM B221 OR ASTM B221							

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

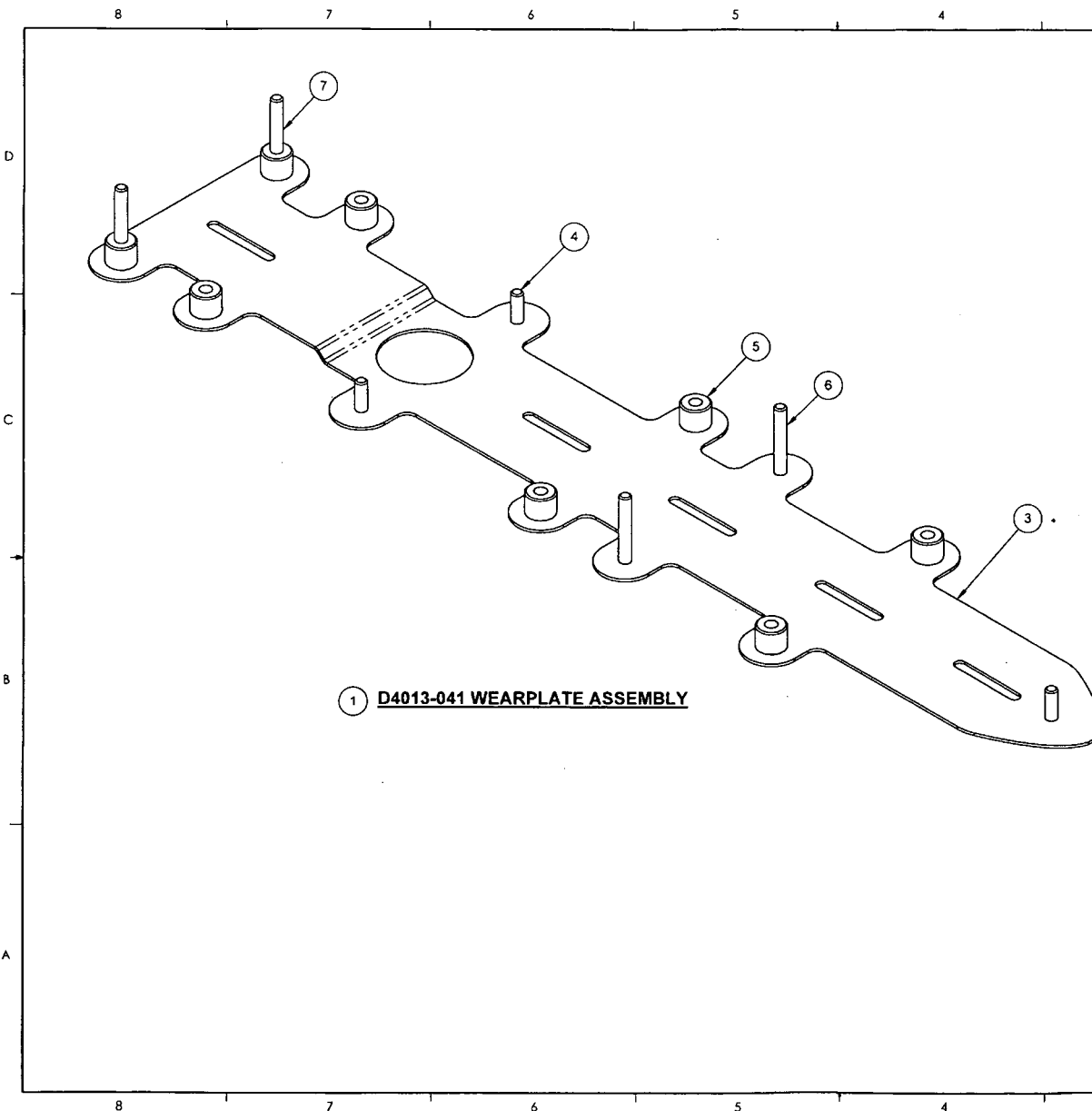
PO Total:

\$375.00

Change Nbr: 1

Change Date: 10/23/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



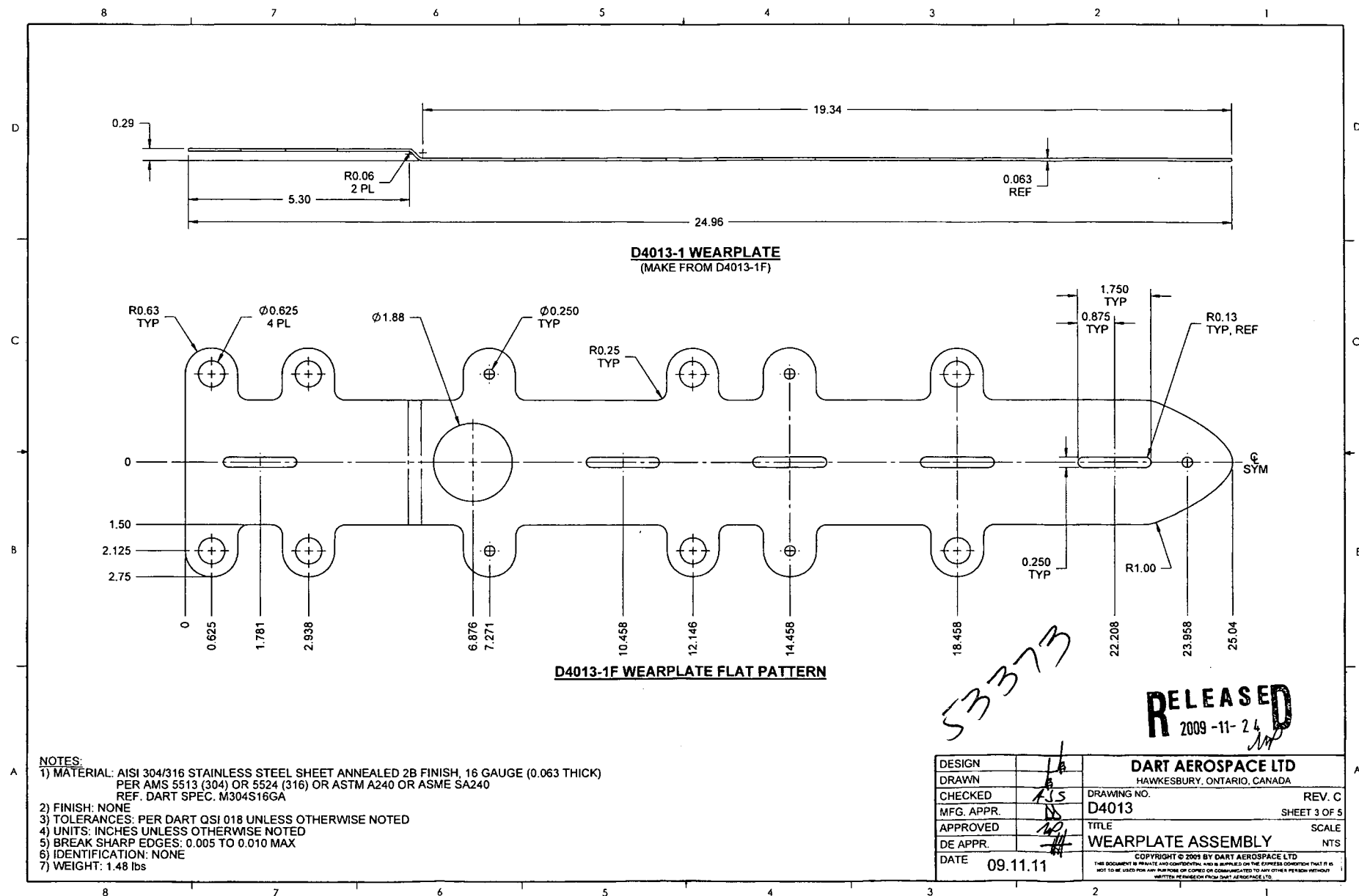
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1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

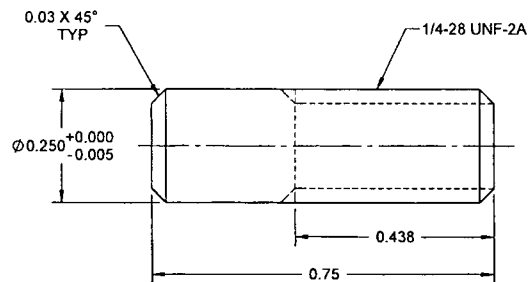
1 D4013-041 WEARPLATE ASSEMBLY

53373

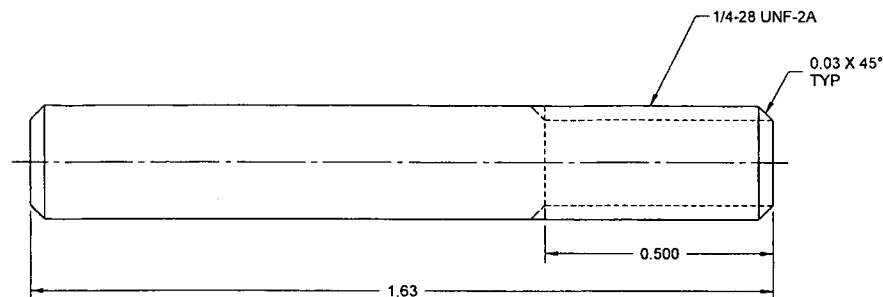
RELEASED
2009-11-24
MP

C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5, ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDEK	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	1/1		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	09.11.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4013 TITLE WEARPLATE ASSEMBLY REV. C SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

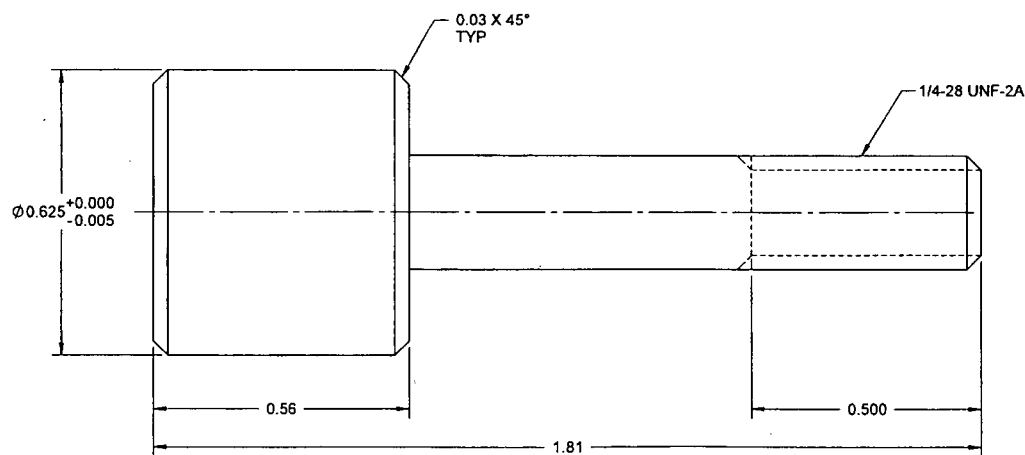




D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

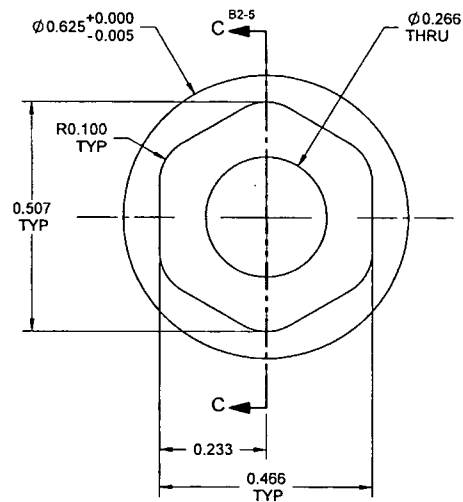
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

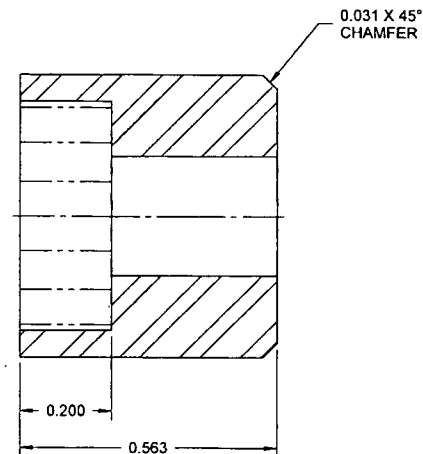
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DS	D4013	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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RELEASED
2009-11-24

53373



D4013-5 CUP



SECTION C-C D6-5

53373

RELEASED
2009-11-24
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. C
MFG. APPR.	1	D4013	SHEET 5 OF 5
APPROVED	1	TITLE	SCALE
DE APPR.	1	WEARPLATE ASSEMBLY	NTS
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